

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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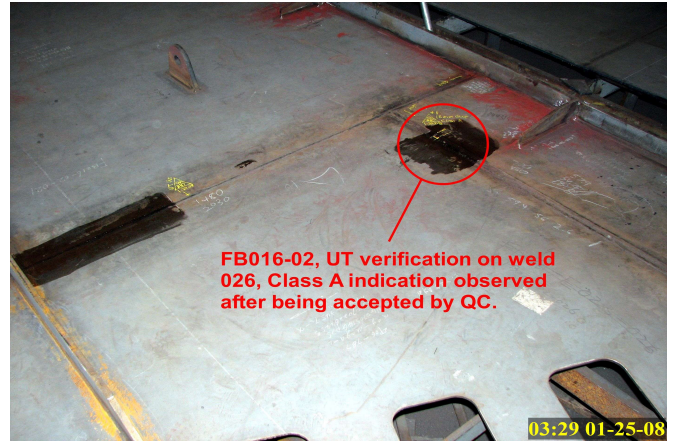
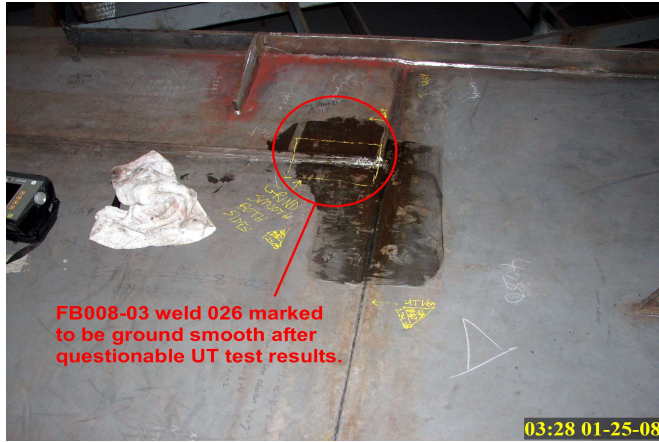
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001326**Date Inspected:** 24-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:****Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:****Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:****Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:****Yes No N/A****Delayed / Cancelled:****Yes No N/A****Bridge No:** 34-0006**Component:** Tower mock up assemblies**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up construction and production construction of the SAS Superstructure.

Bay 7: The QA inspector conducted random visual examination and ultrasonic testing (UT) verification of welds that have been completed and accepted by ZPMC Quality Control (QC) personnel. At the time of 10% examination, FB008-03 weld 023, FB007-02 weld 021, FB016-02 weld 023, FB016-03 welds 023 & 026 appeared to be conforming to the requirements of AWS D1.5 2002 Table 6.3. The QA inspector noted that during the 10% examination of FB008-03 weld 026 and FB007-02 weld 026, there were ultrasonic indications observed that do not satisfy the UT acceptance criteria of AWS D1.5 2002 Table 6.3. The QA inspector noted that these indications could be resulting from the weld geometry. The QA inspector noted that the contract special provisions require that "Groove weld surface profiles that produce questionable test results shall be ground smooth and blended with the adjacent material." The QA inspector marked the examined areas where questionable results were observed and notified the QC Liaison "Ken" Zhang Jiadi of these welds apparent condition. The QA inspector also noted that during the 10% examination of FB016-02 weld 026, there were ultrasonic indications observed that do not satisfy the UT acceptance criteria of AWS D1.5 2002 Table 6.3. The QA inspector noted that this indication appears to be unrelated to the groove weld surface. The QA inspector notified the QC Liaison "Ken" of the rejectable indication that was observed during the UT verification.

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Summary of Conversations:

As noted above, the QA inspector Scott Croff had conversations with the QC Liaison "Ken" Zhang Jiadi. The QA inspector notified the QC Liaison of the UT verification and the observations that are noted above. The QA inspector was informed that the information will be relayed to day shift personnel, as there are no ZPMC QC persons on this shift who are approved for UT. There were no other notable conversations during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
